

Work Order ID 92054

October-22-12 1:42:53 PM

92054

Page 1

Item ID: D2892-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Support

Start Date: 22/10/2012 Start Qty: 14.00

14

Cust Item ID:

Required Date: 03/12/2012 Req'd Qty: 14.00

14

Customer:

Reference:

Approvals: Process Plan: MCS

Date: 12-10-22 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2892

B

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA082
2-Deburr

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

DAS
08
2-09

NCR: ☒ Yes ☐ No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: John Date: 12/12/1QA Closed: ✓ Date: 11

Work Order: <u>92054</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D2892-1</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>12-2144</u>		Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input checked="" type="checkbox"/> Other

Work Order ID 92054

October-22-12 1:42:53 PM

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Page 2

Item ID: D2892-1

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept Reject Reject Insp.
Qty Qty Number Stamp

130

0.00

130

HandFXtube

Memo

0.00

Hand Finishing Crosstubes

Per note 8 on page 1 of dwg D2892, Prep inner concave surface of support and
apply 3M Scotch-Weld as per dwg.
24h of cure time

14

0

0

AS

12-11-23

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

14

DAS
05
2-8

12-11-24

170

Identify as per dwg & Stock Location: **LG52**

0.00

170

Packaging

Memo

0.00

Packaging

14

0

0

AS

12-12-12

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

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Page 3

Item ID: D2892-1

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Revision ID:

Item Name: Support

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Start Date: 22/10/2012 Start Qty: 14.00

14

Cust Item ID:

Required Date: 03/12/2012 Req'd Qty: 14.00

14

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MCS 12-12-12

MCS 12-12-12

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

October-22-12 1:42:57 PM

Page 1

Work Order ID: 92054

92054

Parent Item: D2892-1

D2892-1

Parent Item Name: Support

Start Date: 22/10/2012

Required Date: 03/12/2012

Start Qty: 14.00

Required Qty: 14.00

Comments:

IPP C02.11.26Added P/O KJ

IPP D 08.03.19 Re-format EC verified by: DD

IPP Rev:E

11.08.04 as per dwg rev.B DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK077		Manufactured	No			110	Each	4.0000	0.5	7			

DSK077

D2892-1 TURNING DETAIL

PD 12/4/13

Location

Loc Qty

Loc Code

MAT060

4

82700

4

92190

7

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
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DART AEROSPACE LTD		Work Order:	92054
Description: Ø2.500 Support		Part Number:	D2892-1
Inspection Dwg: D2892	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.115	0.135		.133	.132	.132	.132	.132
AB	0.290	0.310		.310	.310	.310	.310	.310
AC	0.040	0.060		.048	.048	.048	.048	.048
AD	0.115	0.135		.124	.124	.126	.126	.125
AE	0.240	0.260		.249	.250	.250	.250	.250
AF	0.188	0.193		.188	.188	.188	.188	.188
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.146	1.141	1.140	1.145	1.142
AI	0.454	0.474		.469	.469	.466	.466	.471
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.258	.258	.258	.258	.258
AM	1.663	1.683		1.677	1.677	1.677	1.678	1.677
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.022	0.042		.032	.032	.032	.032	.032
AP	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: PD	Date: 12/11/13
Audited by: H.A.	Date: 12/11/13
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.01.31	Dwg Rev updated	KJ	AA

DART AEROSPACE LTD		Work Order:	92054
Description: Ø2.500 Support		Part Number:	D2892-1
Inspection Dwg: D2892	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	0.115	0.135		.132	.132	.132	.132	.132
AB	0.290	0.310		.310	.310	.310	.310	.310
AC	0.040	0.060		.048	.048	.048	.048	.048
AD	0.115	0.135		.124	.124	.124	.124	.125
AE	0.240	0.260		.250	.250	.250	.250	.250
AF	0.188	0.193		.188	.188	.188	.188	.188
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.144	1.142	1.143	1.146	1.141
AI	0.454	0.474		.468	.465	.464	.463	.462
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.258	.258	.258	.258	.258
AM	1.663	1.683		1.675	1.677	1.677	1.677	1.677
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.022	0.042		.032	.032	.032	.032	.032
AP	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by:	PO	Date:	12/11/13
Audited by:	H.A. DAS 08 9-89	Date:	12/11/18
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.01.31	Dwg Rev updated	KJ	AA

1. The first part of the document is a list of names and addresses of the members of the committee. The names are listed in alphabetical order, and the addresses are given in full. The list is as follows:

Mr. J. H. Smith, 123 Main St., New York, N. Y.
Mr. J. D. Jones, 456 Elm St., Boston, Mass.
Mr. W. E. Brown, 789 Oak St., Chicago, Ill.
Mr. R. L. Green, 101 Pine St., Philadelphia, Pa.
Mr. S. K. White, 202 Cedar St., St. Louis, Mo.
Mr. T. M. Black, 303 Maple St., Cincinnati, Ohio.
Mr. U. N. Gray, 404 Birch St., Portland, Me.
Mr. V. O. Hall, 505 Spruce St., Seattle, Wash.
Mr. W. P. King, 606 Fir St., San Francisco, Cal.
Mr. X. Q. Lee, 707 Ash St., Los Angeles, Cal.
Mr. Y. R. Scott, 808 Hickory St., San Diego, Cal.
Mr. Z. S. Walker, 909 Walnut St., San Jose, Cal.
Mr. A. T. Young, 1010 Chestnut St., San Antonio, Tex.
Mr. B. U. Allen, 1111 Elm St., Austin, Tex.
Mr. C. V. Baker, 1212 Oak St., Fort Worth, Tex.
Mr. D. W. Carter, 1313 Pine St., Dallas, Tex.
Mr. E. X. Evans, 1414 Cedar St., Houston, Tex.
Mr. F. Y. Fisher, 1515 Maple St., San Houston, Tex.
Mr. G. Z. Gibson, 1616 Birch St., San Antonio, Tex.
Mr. H. A. Hall, 1717 Spruce St., Austin, Tex.
Mr. I. B. Hill, 1818 Fir St., Fort Worth, Tex.
Mr. J. C. Jones, 1919 Ash St., Dallas, Tex.
Mr. K. D. King, 2020 Hickory St., Houston, Tex.
Mr. L. E. Lee, 2121 Walnut St., San Antonio, Tex.
Mr. M. F. Scott, 2222 Chestnut St., Austin, Tex.
Mr. N. G. Walker, 2323 Elm St., Fort Worth, Tex.
Mr. O. H. Young, 2424 Oak St., Dallas, Tex.
Mr. P. I. Allen, 2525 Pine St., Houston, Tex.
Mr. Q. J. Baker, 2626 Cedar St., San Antonio, Tex.
Mr. R. K. Carter, 2727 Maple St., Austin, Tex.
Mr. S. L. Evans, 2828 Birch St., Fort Worth, Tex.
Mr. T. M. Fisher, 2929 Spruce St., Dallas, Tex.
Mr. U. N. Gibson, 3030 Fir St., Houston, Tex.
Mr. V. O. Hall, 3131 Ash St., San Antonio, Tex.
Mr. W. P. King, 3232 Hickory St., Austin, Tex.
Mr. X. Q. Lee, 3333 Walnut St., Fort Worth, Tex.
Mr. Y. R. Scott, 3434 Chestnut St., Dallas, Tex.
Mr. Z. S. Walker, 3535 Elm St., Houston, Tex.
Mr. A. T. Young, 3636 Oak St., San Antonio, Tex.
Mr. B. U. Allen, 3737 Pine St., Austin, Tex.
Mr. C. V. Baker, 3838 Cedar St., Fort Worth, Tex.
Mr. D. W. Carter, 3939 Maple St., Dallas, Tex.
Mr. E. X. Evans, 4040 Birch St., Houston, Tex.
Mr. F. Y. Fisher, 4141 Spruce St., San Antonio, Tex.
Mr. G. Z. Gibson, 4242 Fir St., Austin, Tex.
Mr. H. A. Hall, 4343 Ash St., Fort Worth, Tex.
Mr. I. B. Hill, 4444 Hickory St., Dallas, Tex.
Mr. J. C. Jones, 4545 Walnut St., Houston, Tex.
Mr. K. D. King, 4646 Chestnut St., San Antonio, Tex.
Mr. L. E. Lee, 4747 Elm St., Austin, Tex.
Mr. M. F. Scott, 4848 Oak St., Fort Worth, Tex.
Mr. N. G. Walker, 4949 Pine St., Dallas, Tex.
Mr. O. H. Young, 5050 Cedar St., Houston, Tex.
Mr. P. I. Allen, 5151 Maple St., San Antonio, Tex.
Mr. Q. J. Baker, 5252 Birch St., Austin, Tex.
Mr. R. K. Carter, 5353 Spruce St., Fort Worth, Tex.
Mr. S. L. Evans, 5454 Fir St., Dallas, Tex.
Mr. T. M. Fisher, 5555 Ash St., Houston, Tex.
Mr. U. N. Gibson, 5656 Hickory St., San Antonio, Tex.
Mr. V. O. Hall, 5757 Walnut St., Austin, Tex.
Mr. W. P. King, 5858 Chestnut St., Fort Worth, Tex.
Mr. X. Q. Lee, 5959 Elm St., Dallas, Tex.
Mr. Y. R. Scott, 6060 Oak St., Houston, Tex.
Mr. Z. S. Walker, 6161 Pine St., San Antonio, Tex.
Mr. A. T. Young, 6262 Cedar St., Austin, Tex.
Mr. B. U. Allen, 6363 Maple St., Fort Worth, Tex.
Mr. C. V. Baker, 6464 Birch St., Dallas, Tex.
Mr. D. W. Carter, 6565 Spruce St., Houston, Tex.
Mr. E. X. Evans, 6666 Fir St., San Antonio, Tex.
Mr. F. Y. Fisher, 6767 Ash St., Austin, Tex.
Mr. G. Z. Gibson, 6868 Hickory St., Fort Worth, Tex.
Mr. H. A. Hall, 6969 Walnut St., Dallas, Tex.
Mr. I. B. Hill, 7070 Chestnut St., Houston, Tex.
Mr. J. C. Jones, 7171 Elm St., San Antonio, Tex.
Mr. K. D. King, 7272 Oak St., Austin, Tex.
Mr. L. E. Lee, 7373 Pine St., Fort Worth, Tex.
Mr. M. F. Scott, 7474 Cedar St., Dallas, Tex.
Mr. N. G. Walker, 7575 Maple St., Houston, Tex.
Mr. O. H. Young, 7676 Birch St., San Antonio, Tex.
Mr. P. I. Allen, 7777 Spruce St., Austin, Tex.
Mr. Q. J. Baker, 7878 Fir St., Fort Worth, Tex.
Mr. R. K. Carter, 7979 Ash St., Dallas, Tex.
Mr. S. L. Evans, 8080 Hickory St., Houston, Tex.
Mr. T. M. Fisher, 8181 Walnut St., San Antonio, Tex.
Mr. U. N. Gibson, 8282 Chestnut St., Austin, Tex.
Mr. V. O. Hall, 8383 Elm St., Fort Worth, Tex.
Mr. W. P. King, 8484 Oak St., Dallas, Tex.
Mr. X. Q. Lee, 8585 Pine St., Houston, Tex.
Mr. Y. R. Scott, 8686 Cedar St., San Antonio, Tex.
Mr. Z. S. Walker, 8787 Maple St., Austin, Tex.
Mr. A. T. Young, 8888 Birch St., Fort Worth, Tex.
Mr. B. U. Allen, 8989 Spruce St., Dallas, Tex.
Mr. C. V. Baker, 9090 Fir St., Houston, Tex.
Mr. D. W. Carter, 9191 Ash St., San Antonio, Tex.
Mr. E. X. Evans, 9292 Hickory St., Austin, Tex.
Mr. F. Y. Fisher, 9393 Walnut St., Fort Worth, Tex.
Mr. G. Z. Gibson, 9494 Chestnut St., Dallas, Tex.
Mr. H. A. Hall, 9595 Elm St., Houston, Tex.
Mr. I. B. Hill, 9696 Oak St., San Antonio, Tex.
Mr. J. C. Jones, 9797 Pine St., Austin, Tex.
Mr. K. D. King, 9898 Cedar St., Fort Worth, Tex.
Mr. L. E. Lee, 9999 Maple St., Dallas, Tex.

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DART AEROSPACE LTD		Work Order:	
Description: Ø2.500 Support		Part Number:	D2892-1
Inspection Dwg: D2892	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	5
HAAS Section								
AA	0.115	0.135		.133	.133	.131	.132	
AB	0.290	0.310		.310	.310	.310	.310	
AC	0.040	0.060		.047	.048	.047	.048	
AD	0.115	0.135		.125	.125	.124	.126	
AE	0.240	0.260		.250	.250	.250	.250	
AF	0.188	0.193		.188	.189	.188	.188	
AG	0.240	0.260		.250	.250	.250	.250	
AH	1.126	1.146		1.143	1.145	1.146	1.142	
AI	0.454	0.474		.463	.464	.448	.445	
AJ	0.240	0.260		.250	.250	.250	.250	
AK	0.053	0.073		.063	.063	.063	.063	
AL	0.257	0.262		.258	.258	.258	.258	
AM	1.663	1.683		1.676	1.677	1.661	1.666	1.660
AN	0.053	0.073		.063	.063	.063	.063	
AO	0.022	0.042		.032	.032	.032	.032	
AP	2.779	2.789		2.784	2.784	2.784	2.784	
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: <u>PO</u>	Date: <u>12/11/14</u>
Audited by: <u>HA</u>	Date: <u>12/11/18</u>
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.01.31	Dwg Rev updated	KJ	AA

NOTES:

1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRc)
(REF DART SPEC. D6104)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 (REF. X.XXX = ± 0.010) UNLESS OTHERWISE NOTED

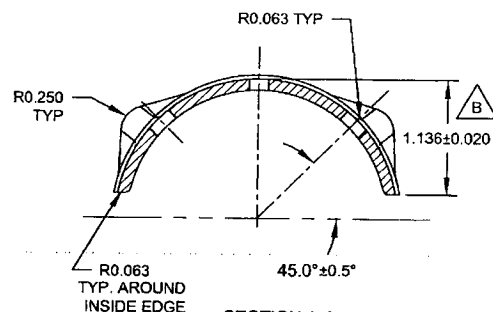
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

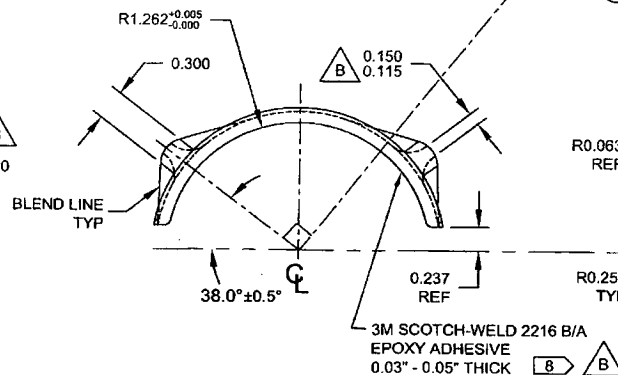
6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP, PER DART QSI 044 6.3.

7) WEIGHT: 0.41 lb

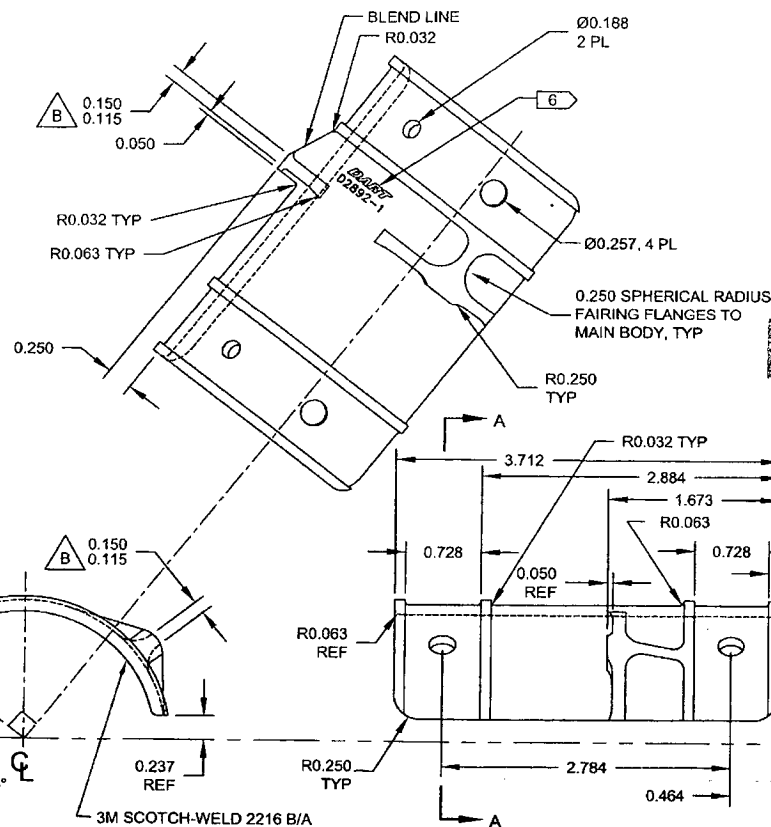
8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.



SECTION A-A



D2892-1 SUPPORT



RELEASED
2011-07-28

B	RMV FINISH, ADD 3M 2216, ADD H925 MATL OPTION, UPDATE TOLERANCE (ZN D5-1,B5-1,B6-1)	CP	11.07.15
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	97	DART AEROSPACE LTD	
DRAWN	97	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.		D2892	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		Ø2.500 SUPPORT	NTS
DATE	11.07.15	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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92054 MCS
12-10-22

